

Date: Wednesday, 2/20/2008 4:16:03 PM
 User: Kim Johnston

Process Sheet

10

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BASKET LID ASSEMBLY	
Job Number	37511A		Part Number	D2989041	
Estimate Number	10206		Drawing Number	D2989 UNDER REVIEW <i>P# 03-02-21</i>	
P.O. Number	:		Project Number	N/A	
This Issue	2/20/2008	S.O. No. :	Drawing Revision	B	
Prsht Rev.	NC		Material	:	
First Issue	/ /	Type : LARGE FAB ASSY	Due Date	3/7/2008	Qty: 1 Um: Each
Previous Run	37247A		Comment	Est Rev:1 Removed D2989-043 05-11-03 JLM	
Written By	:				
Checked & Approved By	:				
Comment	:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D31663	Basket Hoop 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty.(1) D3166-3 Batch: <i>836860</i> PD 03-04-21		
2.0	D2581	Mounting Bracket 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part number Description Batch 2 D2581 Mounting Brackets <i>137248</i> FC 08 04 21		
3.0	D23273	Spacer Bushing 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part number Description Batch 2 D2327-3 Bushing <i>137851</i> FC 08-04-21		
4.0	D2506	Placard 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D2506 Label Plate <i>135585</i> FC 08 04 23		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:16:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 37511A

Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty Part number Description Batch

15sf M304EX0.75-16F Expanded Metal

M107511

FC 08 04 23

6.0 M304TS0750W065

304 SQ Tube.75x.75x.065W



0.065" ~~0.063"~~ 08.04.21

Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x ~~0.063"~~ wall 304/316 SStubing.

Batch: M107515

PD 08-04-22

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

PD 08-04-22

2-Drill holes in tubing as D2989-041 per Dwg D2989

PD 08-04-22

3-Deburr and remove all markings on material

PD 08-04-22

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

PD 08-04-22

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

FC 08 04 23

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989|Identify as D2989-041

PD 08-04-22

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/04/25

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

30 min

25/04/2008

S.120 12.50

#1 99.0 F

#2 33764A F

#3 02989041 F

#4 08-04-25 X

Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

MM 08/04/25 X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:16:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 37511A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M107230

Wing Walk: M107385

M-1 0864/26 *(X)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

M108/04/28

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/28

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 08-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HT</i>	APPROVED <i>HT</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05.08.19

UNDER REVIEW

08-08-05 AM
TURNING TO BE
CHANGED TO 0.065
WILL NOT
03.07.21

PARTS LIST:

Qty -041	Qty -043	Part Number	Description	0.065 03.07.21	NO. 3751A
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)		
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)		
1		D2989-1	STRUT		
1		D2989-2	STRUT		
1		D2989-3	STRUT		
1		D2989-4	STRUT		
2		D2989-5	STRUT		
2		D2989-7	STRUT		
1		D2989-9	STRUT		
1		D2989-10	STRUT		
1		D2989-11	STRUT		
1		D2989-12	STRUT		
2		D2989-13	STRUT		
2		D2989-15	STRUT		
2		D2327-3	SPACER BUSHING		
1		D2506	LABEL PLATE		
2	2	D2989-17	STRUT (96.00" LONG)	SHOP COPY	
2		D2989-19	STRUT (31.19" LONG)	RETURN TO ENGINEERING	
1		D2512-7	STRUT	UNCONTROLLED COPY	
2		D2581	MOUNTING BRACKET	SUBJECT TO AMENDMENT	
	2	D3182-1	HINGE	WITHOUT NOTICE	
	2	D3442-3	SHIM	WORK ORDER	

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



